

Work Order ID 57744

April 14, 2010 11:36:33 AM



Page 1

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 14

Date: 10-4-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B10-4-14

(11)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-4-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sidley 1/5

(711)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

April 14, 2010 11:36:33 AM

Accept

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Required Date: 22/04/2010 **Req'd Qty:** 10.00

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop 

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

130

0.00



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

Thermoforming Machine

Without removing protective skin □ remove sharp edge by degurring.

0.00

140

THERMOFORMING MACHINE

0.00

Thermoform

Memo

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 ☐ Dwg.
Rev. C ☐ Folio Rev B ☐ 2-Engrave part# &
batch#, ☐ (D3290-3)

0.00

150

[illegible]

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/15	140						

Part No: D3290-3 PAR #: N/A Fault Category: Thermal NCR: Yes No DQA: A Date: 10.04.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: _____

NCR: 57744		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/15	140	Received 4 chipped windows. from QA inspection were accidentally damaged	<u>VB</u> Q9 Den	Scrap & destroy Qty 4	10/04/16 Ph.	<u>S</u> 10/04/16	<u>VB</u> Q9 Den	<u>VB</u> 10.04.16
		RL were knocked off QC shelf when a employee was moving 3/4" sq tubing. LOA						

NOTE: Date & initial all entries

Work Order ID 57744

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

AB 14-04-16 (x7)

170

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches if required

Wh 14/04/16 (x7)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8:10:04/16

(x7)

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo *use on w/o 57548*

0.00

Packaging

7

*SAD
10-04-16*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/04/19**MF
10-4-19*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:36:39 AM

Page 1

Work Order ID: 57744

Parent Item: D3290-3

Parent Item Name: Window

Comments: IPP A ☐ 04.08.18 ☐ New issue ☐ KJ/RF ☐
IPP B ☐ 06.05.09 ☐ Ecn 798 EC ☐
IPP C 07.05.29 Thermoform in-house DL
IPP D 07.09.28 rev C dwg EC verified by: DD

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

MACRLICS.125

Purchased No

100 sf

100.0000 31.5789

35,



10-4-14

1/8" Polycast II Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

100

113204

4

113861

96

11

113861

W/O:		WORK ORDER CHANGES					
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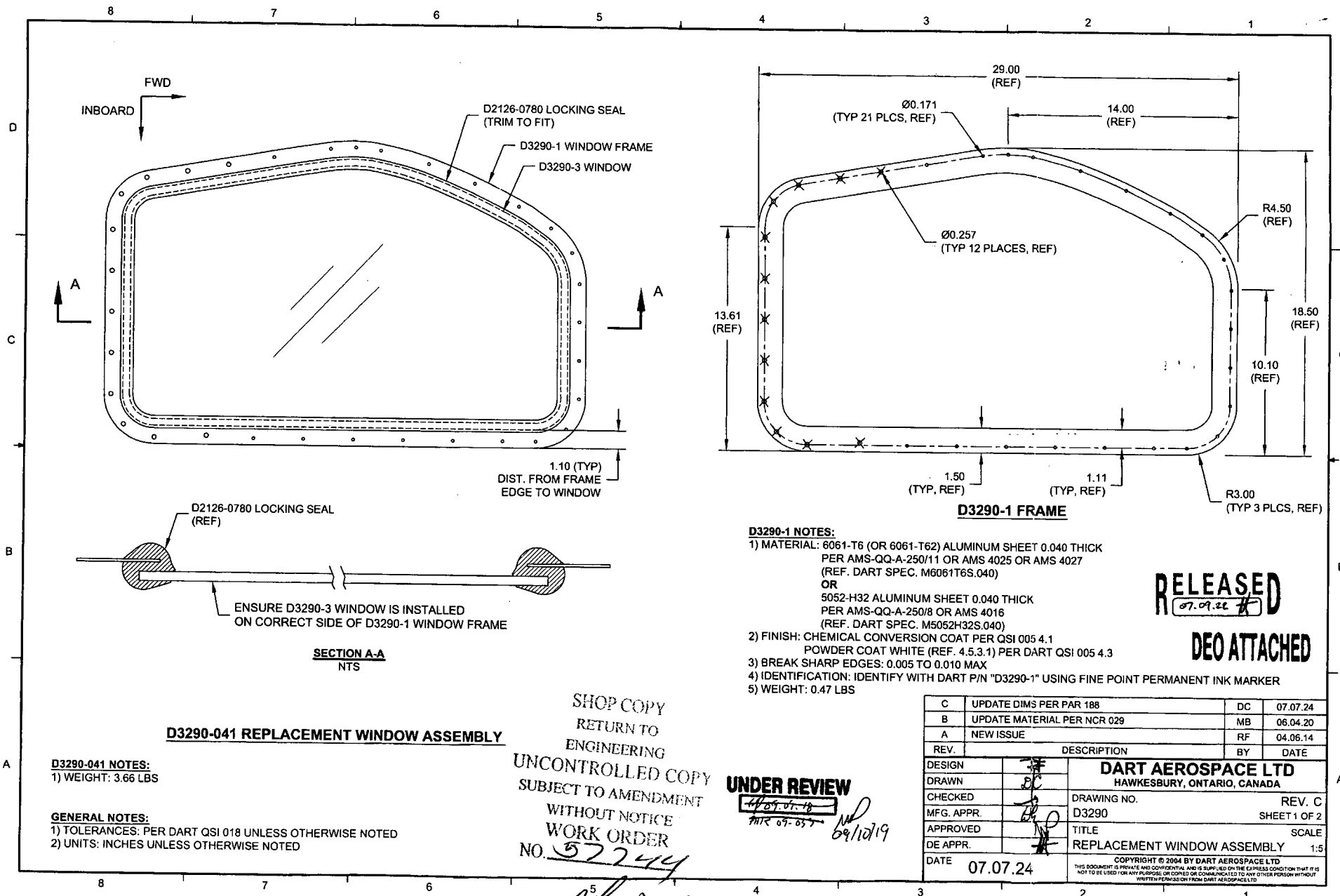
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NOTE: Date & initial all entries



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 52244

UNDER REVIEW

4/07.07.18
 7/12/07.05.17
 6/10/19

10-4-14

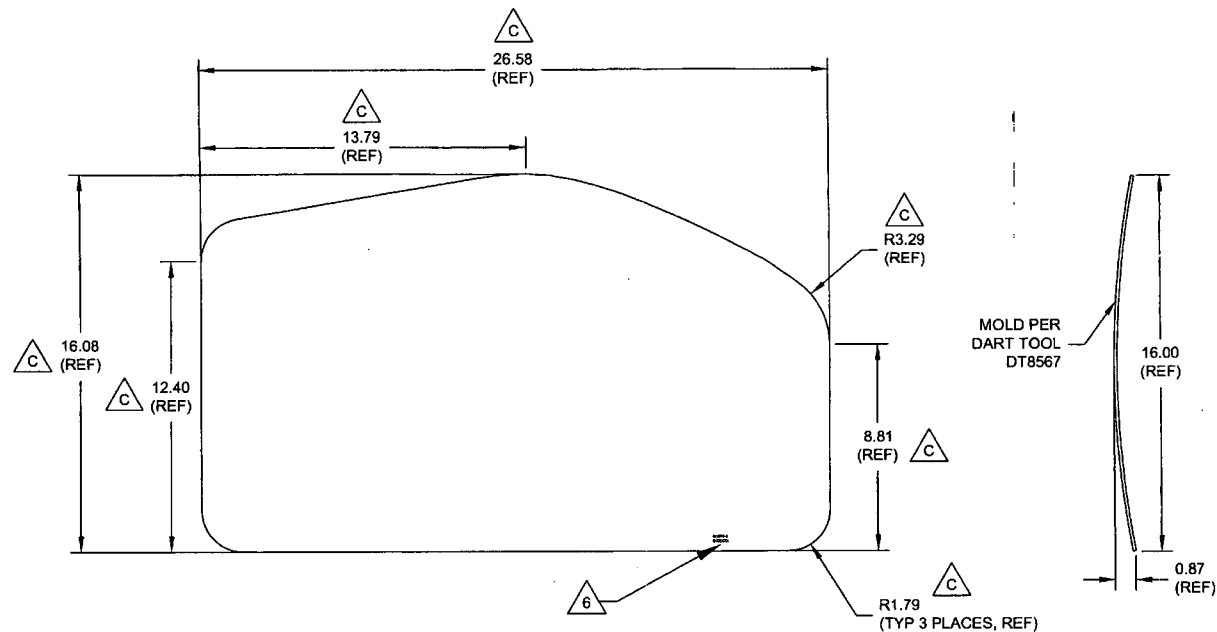
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NOTE: Date & initial all entries



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

UNDER REVIEW

DEO ATTACHED
RELEASED

w/o 577414

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>h</i>	MFG. APPR. <i>FE</i>	APPROVED <i>AD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
WMP

WLO 57744

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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